Work Order ID 63272

Wednesday, October 27, 2010 9:07:09 AM

Item ID: D212-725-1-155F **Accept**

Revision ID:

Item Name: Support Angle Oil Cooler

Setup Start / Stop

Start Date: 10/27/2010 **Start Qty:** 2.00

Required Date: 11/30/2010 **Req'd Qty:** 2.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ____ **Date:** 101027 **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Run Start / Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D212-725-1	E

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Waterjet FLOW CNC Waterjet 2024 .032	**Memo** 1-Cut as per Dwg Dwg Rev: E Prog Rev: E 2-Deburr if necessary	0.00 0.00	B10-10-28			(2)
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00	B10-10-28			

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ___________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63272

Wednesday, October 27, 2010 9:07:09 AM

Item ID: D212-725-1-155F **Accept**

Setup **Start**

Revision ID:

Stop

Item Name: Support Angle Oil Cooler

Start Date: 10/27/2010 **Start Qty:** 2.00

Cust Item ID:

Required Date: 11/30/2010 **Req'd Qty:** 2.00

Customer:

Reference:

Run **Start**

Stop

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ____________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00 S 10/10/28				+2			
130 Brake NC Brake NC	Bend as per dwg **Memo**	0.00 0.00 SB 10/10/28				2			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 S 10/10/29				+2			

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 63272

Wednesday, October 27, 2010 9:07:09 AM

Item ID: D212-725-1-155F **Accept** **Setup Start**

Revision ID:

Item Name: Support Angle Oil Cooler **Stop**

Start Date: 10/27/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 11/30/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start**

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	10/10/29			2	0		
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				10/10/29			(2)
170 Packaging Packaging	Identify as per dwg & Stock Location: 3F4 Memo	0.00 0.00				10/10/29			(2)

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES					

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 63272

Wednesday, October 27, 2010 9:07:09 AM

Item ID: D212-725-1-155F **Accept** **Setup Start**

Revision ID:

Item Name: Support Angle Oil Cooler **Stop**

Start Date: 10/27/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 11/30/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00					10/10/29		
QC	Memo	0.00							
Quality Control									

MF

10-10-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, October 27, 2010 9:07:13 AM

Work Order ID: 63272

Parent Item: D212-725-1-155F

Parent Item Name: Support Angle Oil Cooler

Start Date: 10/27/2010 **Required Date:** 11/30/2010

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032 2024-T3 .032 sheet		Purchased	No			100	sf	72.0000	0.085	0.178947	B10-10-28		

Location		Loc Qty	Loc Code	
MAT22		72		
	105555	3		
	111699	4		
	113189	65		113189

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order: 63272
Description: Support Angle oil Cooler	Part Number: D212725-1-155F
Inspection Dwg: D212-725-1-155F, Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

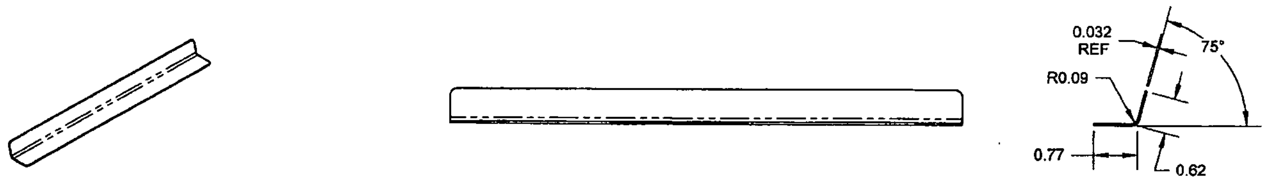
[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.35	+/- .030	1.337	X		IB V02	
9.05	+/- .030	9.028	X		IBPRO 02	
.032	+/- .010	.032	X		✓	

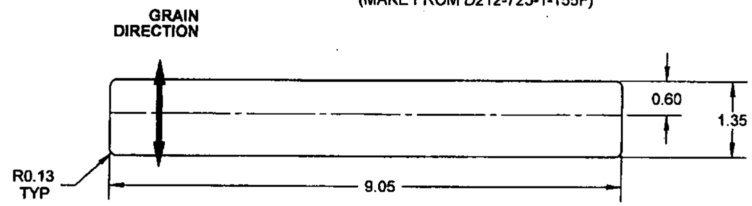
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Date: 10-10-28	Date: 10/10/28	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY
UNCONT[illegible]
SUBJECT TO [illegible]
WITHOUT [illegible]
WORK ORDER
NO. 63272
BP 10-10-27

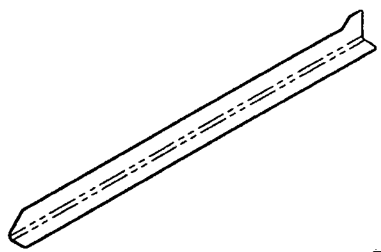


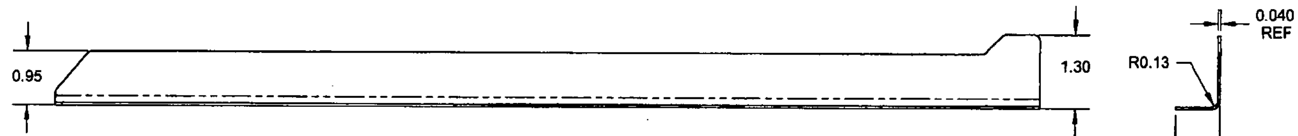
D212-725-1-155 ANGLE
(MAKE FROM D212-725-1-155F)



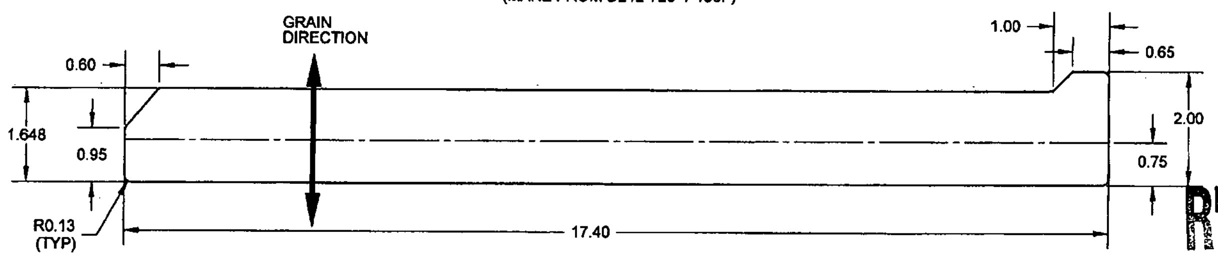
D212-725-1-155F FLAT PATTERN

D212-725-1-155 NOTES:
1) MATERIAL: 2024-T3 SHEET 0.032 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.032)
2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: N/A





D212-725-1-153 ANGLE (E)
(MAKE FROM D212-725-1-153F)



(E) D212-725-1-153F FLAT PATTERN

RELEASED
2009-10-28

D212-725-1-153 NOTES:
1) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: N/A

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DS	DRAWING NO. D212-725-1 — REV. E — SHEET 52 OF 82
MFG. APPR.	N/A	
APPROVED	[signature]	TITLE 212S DETAIL PARTS — SCALE NTS
DE APPR.	[signature]	
DATE	08.09.17	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries